Tuesday, 23/12/2008 3:30:42 PM

User:

Julie Dawson

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 11168

: 44319

Estimate Number

P.O. Number

This Issue

Prsht Rev.

First Issue

Comment

Previous Run

: 23/12/2008

: NC

: 11

: 43411

Type : MACHINED PARTS

S.O. No. :

Part Number

Drawing Name

: D22823 : D2282 REV E

Drawing Number Project Number

: N/A : E

: TUBE

Drawing Revision

Material

Due Date

: 20/01/2009

Qty:

50 Um: Each

Checked & Approved By

Written By

: Est Rev:A

08-12-24 Removed from 9 Digit

05-12-02 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

M304TR0675W091 1.0

304 RD Tube .675 x .091W



Comment: Qty.:

0.2078 f(s)/Unit Total:

10.3898 f(s)

Material: T304/T316 3/8 Schedule 40, Seamless, Ø0.675" OD, 0.091" wall thickness

(M304TR0.675W.091)

Batch MIGG 364

J.F./ \$ 08/12/29

2.0

Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Dwg D2282 and Folio FA188

2-Deburr

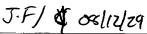
J.F/08/12/29

INSPECT PARTS AS THEY COME OFF MACHINE



3.0

QC2





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK





Comment: SECOND CHECK



5.0

PACKAGING 1

PACKAGING RESOURCE #1



Identify and Stock



Comment: PACKAGING RESOURCE #1

Location:

Dart Aerosp	pace Ltd
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	•				1					
W/O:			WO	RK ORDER CHANG	ES					
DATE STEP		PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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					1					
Part No	:	PAR #:	Fault Categ	jory:	NC	R: Yes	No DQ	A :	Date: _	
	Res	olution:	Disposition	l:	QA	: N/C Cld	osed:		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE	(NCR)			
DATE	STEP	Description of NC	cription of NC Corrective Action			0: 0		cation	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sect	ion C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

Date:

Tuesday, 23/12/2008 3:30:42 PM

User:

Julie Dawson

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Process Sheet

Job Number: 44319

Part Number: D22823

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08-12-31

W/O:		WORK ORDER CHANGES									
DATE STEP		PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	•	PAR #:	Fault Cat	egory:	NC	R: Yes	No DQA	:	Date:		
	R	esolution:	Disposition	on:	QA	: N/C Cld	osed:		Date:		
NCR:		•	WORK ORE	DER NON-CONFORMA	VCE	(NCR)				
		Description of NC		Corrective Action Section	n B		Verific	ation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector	

NCR:		World Officer Cold Offinal Cold							
		Description of NC		Corrective Action Section B	Verification	A	Annessal		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
	i i								
							11		
)	!		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 44319
Description: Handle Tube	Part Number: D2282-3
Inspection Dwg: D2282 Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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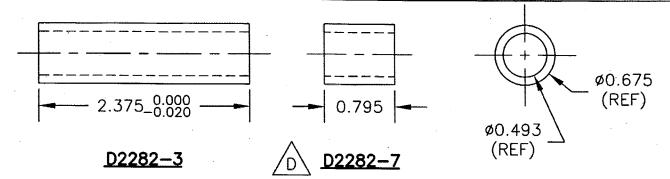
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.375	+0.000/-0.020	2.366				
	-					
					<u> </u>	
						
		<u> </u>				
						

Measured by:	4	Audited by:	JL.	Prototype Approval:	N/A
Date:	04/12/29	Date:	08/12/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-04	1 KJ/RF	
В	05.04.19	Tolerance changed	KJ/JLM , ,	1
С	06.03.15	Dwg Rev update	KJ/JLM A	- 411

DESIG	и BW	DRAWN BY	DART AERO HAWKESBURY, O	
CHEC	KED P	APPROVED	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE	· · · ·		TITLE	SCALE
05.0	06.07		HANDLE TUBES	1:1
_		04.40.44	NEW ISSUE	

05,0	06.07	HANDLE TUBES 1:
Α	94.10.14	NEW ISSUE
В	95.03.23	RE-DESIGN
c ·	97.10.20	CORRECTED NUMBERING SCHEME
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750
Ε	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED R0.063 x 0.063 DEEP 4 0.090 x 45° 0.95 -CHAMFER 0.158 Ø0.700 R0.350 -Ø0.386 0.125 $0.080 \times 45^{\circ}$ SHOP COPY (REF) **CHAMFER RETURN TO ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT D2282-5 WITHOUT NOTICE WORK ORDER NO_44A

D2282-5 STEM:

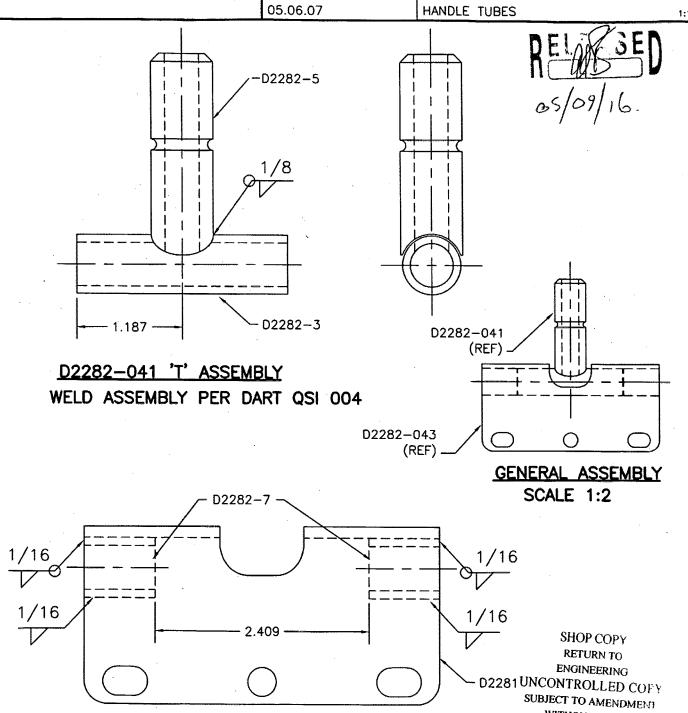
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN BW	DRAWN BY	DART AEROS HAWKESBURY, ONT.	
CHECKED	APPROVED	DRAWING NO.	REV. E
u'	1 and	D2282	SHEET 2 OF 2
DATE		TITLE	SCALE
05.06.07		HANDLE TUBES	1:1



WITHOUT NOTICE

WORK ORDER

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D2282-043 SADDLE ASSEMBLY

WELD ASSEMBLY PER DART QSI 004